
 KANEPACKAGE PHILIPPINE INC. No. 5 Ring Road LISP II, Brgy. La Mesa, Calamba City, Laguna Telephone No. (049) 545-7166 to 69 Fax No. (049) 545-6302	<h1>INVESTIGATION REPORT</h1>		
	Prepared By:	Check By:	Approved By:
	K. DIAZ QA-IE/ Prodn IE	N. CEPEDA QA/ Prodn SV	R. MIRANDA KPLIMA Operations Gen. Mngr.
DATE:	JULY 27 2023		

5M REVIEW		DOCUMENT REVIEW				
MAN	No Changes	Affected Document:	Date Reviewed:	Disposition:	PIC:	Target Date:
MACHINE	No Changes	Procedure Manual		With Revision <input checked="" type="checkbox"/> No Revision <input checked="" type="checkbox"/>	K. DIAZ	N/A
MATERIAL	No Changes	Work Instruction		With Revision <input checked="" type="checkbox"/> No Revision <input checked="" type="checkbox"/>	K. DIAZ	N/A
METHOD	No Changes	Process Flow		With Revision <input checked="" type="checkbox"/> No Revision <input checked="" type="checkbox"/>	K. DIAZ	N/A
ENVIRONMENT	No Changes	Forms		With Revision <input checked="" type="checkbox"/> No Revision <input checked="" type="checkbox"/>	K. DIAZ	N/A

I. PROBLEM DESCRIPTION

1.1. ISSUE:	
	Damage
1.2. ITEM DESCRIPTION:	
PART CODE:	516513000 / 515913300
PART NAME:	LIGHT 2 MB AMERICA / LOUVRE 2 MJX
1.3. BACKGROUND:	
PICTURE 	DETAILS: >Inhouse Detection :DAMAGE >Lot size: 1693pcs > Reject Qty: 70pcs >Rejection Rate: 4.13%

II. IMMEDIATE ACTION

ACTION ITEMS	Target Date:	Person In-charge
The manual detaching operator report to the subleader that the item was uncut.	JULY 27 2023	Sub-leader and Die cut operator

III. CAUSE ANALYSIS:

WHY 1:	Damaged occurred during manual detaching process.
WHY 2:	Damaged encountered due to accidentally cut of edge part of board/panel instead of scrap part. Note: The item to be manually detach was stack in flip flop (Light Model).
WHY 3:	The operator in-charge mislook the cutting portion.
WHY 4:	Standard quantity of removing scrap was not followed by the in-charge operator.

IV. ACTION PLAN:

1	Generate OPL (One Point Lesson) for the standard stacking of Light Models prior inline manual detaching process.	PIC: Production IE Target Date: August 5, 2023
2	Re-educate the operator in-charge regarding the proper detaching process of items and proper placing of detach item in the wip area. Reference: OPL (One Point Lesson) for the standard quantity of removing scrap.	PIC: Production IE Target Date: August 5, 2023



POST SIGNAGE AT DIE-CUT 3

KANEPACKAGE PHILIPPINE INC.

MINUTES OF THE MEETING

Date	Time	Place	Topic	Minutes	Sign
2023-07-10	10:00 AM	Die-Cut 3	Scrap Handling	Handwritten notes on scrap handling procedures.	Handwritten signature.

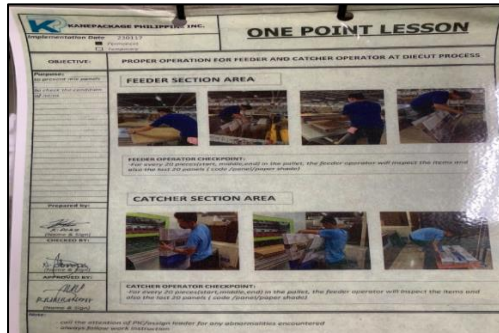
AGENDA:

- Division of scrap handling into two sections: wide and small.

MINUTES:

Discussed scrap handling procedures and the need for scrap items and scrap items. The scrap items are the scrap items that are not used in the production process. The scrap items are the scrap items that are not used in the production process. The scrap items are the scrap items that are not used in the production process.

ATTENDANCE SHEET



ONE POINT LESSON